

WHAT IS CLAIMED IS:

1 1. A miniature fiberoptic filter comprising
2 a first optical fiber;
3 a first multimode optical fiber segment attached to an end of said first optical
4 fiber, said first multimode optical fiber segment having a step index of refraction and axially
5 aligned with said first optical fiber, said first multimode optical fiber segment having a first
6 length;
7 a second multimode optical fiber segment attached to said first multimode optical
8 fiber segment, said second multimode optical fiber segment having a graded index of refraction
9 core and axially aligned with said first multimode optical fiber segment, said second multimode
10 optical fiber segment having a second length, said first and second lengths selected to define a
11 collimation and focusing function for light from and to said first optical fiber;
12 a plurality of dielectric coatings on an end of said second multimode optical fiber
13 segment opposite said first multimode optical fiber segment, said plurality of dielectric coatings
14 forming a wavelength-dependent optical filter;
15 a second optical fiber;
16 a third multimode optical fiber segment attached to an end of said second optical
17 fiber, said third multimode optical fiber segment having a step index of refraction and axially
18 aligned with said second optical fiber, said third multimode optical fiber segment having a third
19 length; and
20 a fourth multimode optical fiber segment attached to said third multimode optical
21 fiber segment, said fourth multimode optical fiber segment having a graded index of refraction
22 core and axially aligned with said third multimode optical fiber segment, said fourth multimode
23 optical fiber segment having a fourth length, said third and fourth lengths selected to define a
24 collimation and focusing function for light from and to said second optical fiber, said fourth
25 multimode optical fiber segment having an end opposite third multimode optical fiber segment
26 and facing said end of said second multimode optical fiber segment;
27 said first optical fiber, said first multimode optical fiber segment, said second
28 multimode optical fiber segment, said plurality of dielectric coatings, said second optical fiber,
29 said third multimode optical fiber segment, said fourth multimode optical fiber segment arranged

30 and oriented with each other so light from said core of said first optical fiber passing through
31 said plurality of dielectric coatings enters said core of said second optical fiber.

1 2. The miniature fiberoptic filter of claim 1 comprising
2 a cylindrical package holding an end section of said first optical fiber, said first
3 multimode optical fiber segment, said second multimode optical fiber segment, an end section of
4 said second optical fiber, said third multimode optical fiber segment, said fourth multimode
5 optical fiber segment, said cylindrical package having an outside diameter less than 0.4mm.

1 3. The miniature fiberoptic filter of claim 2 wherein said cylindrical package
2 comprises metal sleeves engaging portions of said end sections of said first and second optical
3 fibers, each portion having a metal coating and closely engaging a metal sleeve.

1 4. The miniature fiberoptic filter of claim 3 wherein said cylindrical package
2 has a circular cross-section.

1 5. The miniature fiberoptic filter of claim 3 wherein each metal coating is
2 fixed to its corresponding metal sleeve.

1 6. The miniature fiberoptic filter of claim 5 wherein each metal coating is
2 fixed to its corresponding metal sleeve by a laser solder.

1 7. The miniature fiberoptic filter of claim 5 wherein each metal coating is
2 fixed to its corresponding metal sleeve by a laser weld.

1 8. The miniature fiberoptic filter of claim 1 wherein said plurality of
2 dielectric coatings form a low-pass filter.

1 9. The miniature fiberoptic filter of claim 1 wherein said plurality of
2 dielectric coatings form a high-pass filter.

1 10. The miniature fiberoptic filter of claim 1 wherein said plurality of
2 dielectric coatings form a bandpass filter.

1 11. The miniature fiberoptic filter of claim 1 wherein said end of said second
2 multimode optical fiber segment is angled from a plane perpendicular to a longitudinal axis of
3 said second multimode optical fiber segment.

1 12. The miniature fiberoptic filter of claim 11 comprising said end of said
2 fourth multimode optical fiber segment is reciprocally angled with respect to said end of said
3 second multimode optical fiber segment.

1 13. A method of manufacturing a miniature fiberoptic filter comprising
2 fixing first and second multimode fiber segments to a first optical fiber end
3 section, said first multimode fiber segment between said first optical fiber end section and said
4 second multimode fiber segment, said first multimode fiber segment having a step index of
5 refraction and said second multimode fiber segment having a graded index of refraction core;
6 selecting lengths of said first and second first and second multimode fiber
7 segments to define a collimation and focusing function for light from and to said first optical
8 fiber end section;
9 depositing a plurality of dielectric layers upon an end surface of said second
10 multimode fiber segment opposite said first multimode fiber segment, said plurality of dielectric
11 layers defining a wavelength- dependent filtering function;
12 fixing third and fourth multimode fiber segments to a second optical fiber end
13 section, said third multimode fiber segment between said second optical fiber end section and
14 said fourth multimode fiber segment, said third multimode fiber segment having a step index of
15 refraction and said fourth multimode fiber segment having a graded index of refraction core;
16 selecting lengths of said third and fourth multimode fiber segments to define a
17 collimation and focusing function for light from and to said second optical fiber end section; and
18 arranging and orienting said first optical fiber end section and fixed first and
19 second multimode fiber segments with said second optical fiber end section and fixed third and
20 fourth multimode fiber segments so light from a core of said first optical fiber end section
21 passing through said plurality of dielectric coatings enters a core of said second optical fiber end
22 section.

1 14. The method of claim 13 further comprising

2 angle-polishing said end surface of said second multimode fiber segment and an
3 end surface of said fourth multimode fiber segment opposite said third multimode fiber segment
4 so that said end surfaces are angled from a perpendicular to a longitudinal axis of said second
5 and fourth multimode fibers segments respectively.

1 15. The method of claim 14 wherein said angle-polishing step comprises
2 simultaneously angle-polishing end surfaces of a plurality of multimode fiber segments in a
3 fixture having an angle-polishing guide surface at an angle to a perpendicular plane to said
4 plurality of multimode fiber segments in said fixture.

1 16. The method of claim 15 wherein said angle-polishing step comprises
2 simultaneously angle-polishing end surfaces of at least _____ multimode fiber segments.

1 17. The method of claim 13 wherein said first and third multimode fiber
2 segments comprise step index multimode fiber segments, and wherein said selecting steps
3 comprise selecting lengths of said first and third multimode segments approximately 610 μ m.

1 18. The method of claim 13 wherein said second and fourth multimode fiber
2 segments comprise graded index fiber segment, and wherein said selecting steps comprise
3 selecting lengths of said second and fourth multimode segments approximately 135 μ m.

1 19. The method of claim 13 further comprising
2 forming metal coating over predetermined portions of said first and second optical
3 fiber end sections; and

4 fitting a metal sleeve over said first optical fiber end section with said fixed first
5 and second multimode fiber segments and said second optical fiber end section with said fixed
6 third and fourth multimode fiber segments; and

7 fixing said metal sleeve to said metal coatings.

1 20. The method of claim 19 wherein said fitting step comprises selecting a
2 metal sleeve having an outside diameter less than 0.4mm.